

Date: Tuesday, 13/05/2008 10:11:46 AM  
 User: Linda Lacelle

## Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : DOUBLER ASSEMBLY
<b>Job Number</b> : 39186A	
<b>Estimate Number</b> : 10784	
<b>P.O. Number</b> :	<b>Part Number</b> : D31511
<b>This Issue</b> : 13/05/2008 <b>S.O. No.</b> :	<b>Drawing Number</b> : D3151 REV C
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : / / <b>Type</b> : SMALL / MED FAB	<b>Drawing Revision</b> : C
<b>Previous Run</b> : 39186A	<b>Material</b> :
<b>Written By</b> :	<b>Due Date</b> : 30/05/2008 <b>Qty:</b> 4 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> :	
<b>Comment</b> : Est A04.12.01 New issue KJ/JLM Est Rev:B 08-05-12 now made on water jet DD verified by:EC	

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	M2024T3S040	2024-T3 .040 sheet
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0.0860



0.3438



*08/05/13*  
**Comment:** Qty.: ~~26.2500~~ sf(s)/Unit Total: 405.0000 sf(s)

Material: 2024-T3 (QQ-A-250/4) 0.040" thick  
 (M2024T3S.040)

Batch: 107572 B 8-S-14

2.0	WATER JET	FLOW WATER JET
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**Comment:** FLOW WATER JET

1-Cut as per Dwg D3151

Dwg Rev: C

Prog Rev: C

B 8-S-14

⑥

2-Deburr if necessary

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

B 8-S-14

4.0	QC8	SECOND CHECK
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**Comment:** SECOND CHECK

08/05/14 ④6

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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**Comment:** SMALL & MEDIUM FAB RESOURCE 1

Deburr D3151-1

C'sink holes as per Dwg D3151

ml 08/05/10 x6

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Drawing Name: DOUBLER ASSEMBLY

Job Number: 39186A

Part Number: D31511

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/05/16 (x6)

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

W/F 08/05/16 (x6)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT CHEMICAL CONVERSION COAT

AS 08/05/16 (x6)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #

Identify part with permanent fine point marker and Stock

Location: 5772

AS 08/05/16 (x6)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/05/2008

Job Completion



MF 08-05-16

**DART**

DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3151	REV: C SHEET 1 OF 1
DATE 05.12.07	TITLE DOUBLER ASSEMBLY		SCALE 1:4
A	02.04.23	NEW ISSUE	
B	04.09.08	RE-DESIGN	
C	05.12.07	REVISE NOTES	

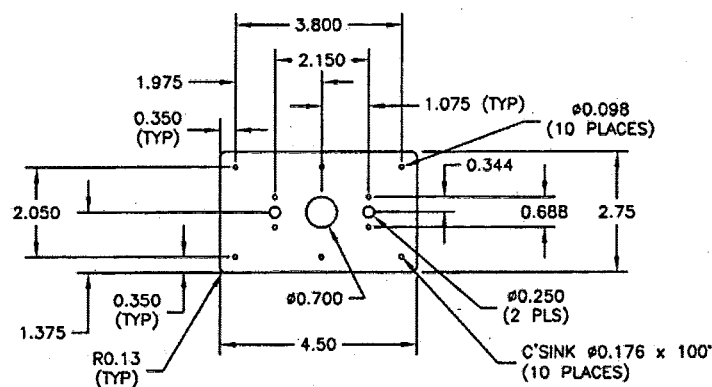
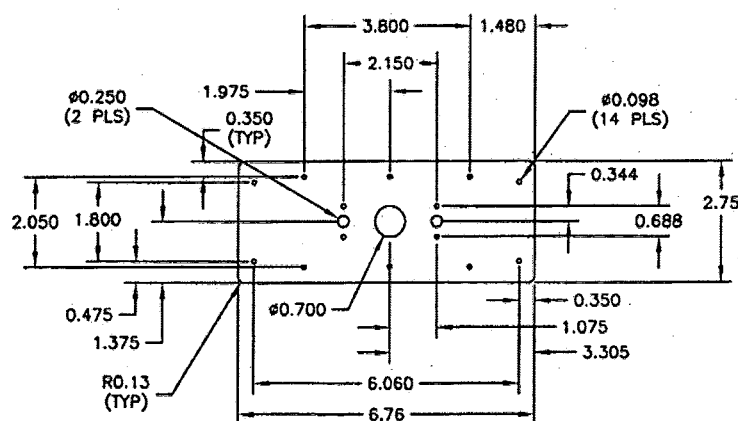
MS20426AD3-3 RIVET (1)  
(6 PLACES)MS21059L08 NUTPLATE (1)  
MS20426AD3-4 RIVET (2)  
(2 PLACES)

D3151-3

D3151-1

**D3151-041 DOUBLER ASSEMBLY**  
REPLACES PREMIER P/N B30-23000-173/-174**RELEASED**

05.12.07

**D3151-1****D3151-3****NOTES**

- 1) MATERIAL: 2024-T3 SHEET (QQ-A-250/4) 0.040" THICK (REF. DART SPEC. M2024T3S.040)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010
- 6) IDENTIFY WITH DART P/N D3151-041 USING FINE POINT PERMANENT INK MARKER

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